

Work Order ID 66892

Wednesday, March 02, 2011 10:24:41 AM



Page 1

Item ID: D3769-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 3/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-03-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3769	Rev A								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-cut tube to lenght as per dwg D3769 2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig 3- deburr								
									<i>EM-L 11/03/16</i>
110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
									<i>SB 11/03/16</i>
120		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
									<i>10 BK 11-3-17</i>

(10X)

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66892

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Page 2

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Setup Start



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Item Name: Tube

Start Date: 3/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10	0	11/03/17	
140 Packaging Packaging	Identify as per dwg & Stock Location <u>251A</u> Memo	0.00 0.00				11/3/17	5/102		
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/3/18	

11/03-17
10

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Picklist Print

Wednesday, March 02, 2011 10:24:54 AM

Page 1

Work Order ID: 66892

Parent Item: D3769-3

Parent Item Name: Tube



Start Date: 3/2/2011

Required Date: 3/7/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T1.000W065

Purchased

No

100

f

50.5728

1.265

13.31579



6061T6 RD TUBE 1.00 x .065w



m-2 11/03/16

Location

Loc Qty

Loc Code

MAT

27.60526

116720 ✓

27.60526

MAT015

22.96757748

113511

13.7388405

114089

9.228737

13-31579

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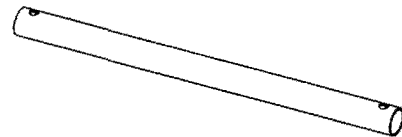
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

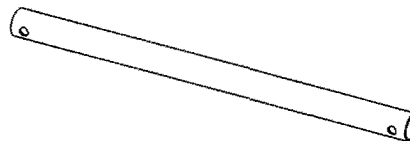
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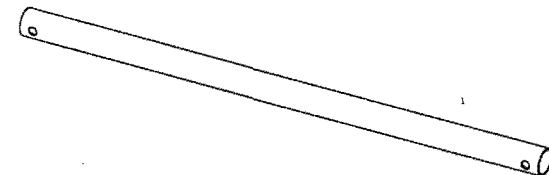
11-03-2
NO 46892
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER



D3769-1 TUBE



D3769-3 TUBE



D3769-5 TUBE

RELEASED
08-06-17

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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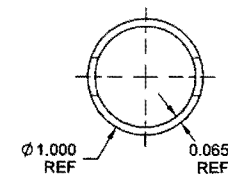
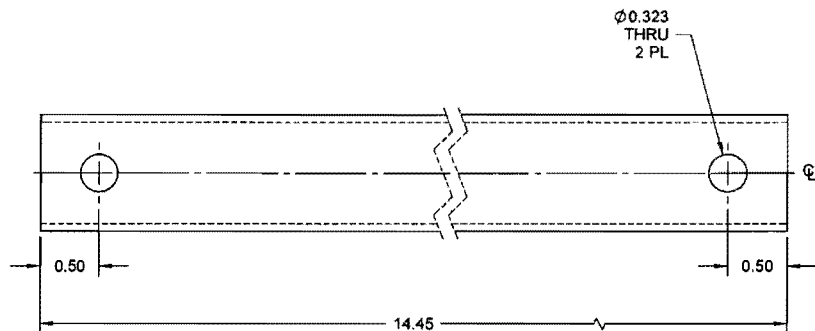
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13877 9/77



D3769-1 TUBE

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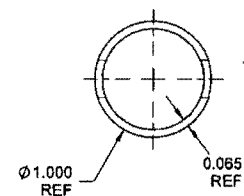
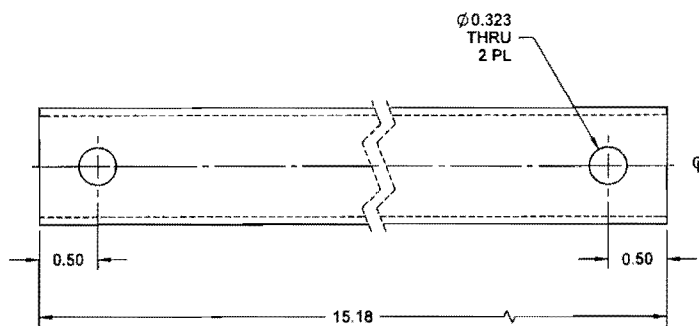
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D3769-3 TUBE

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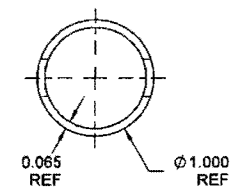
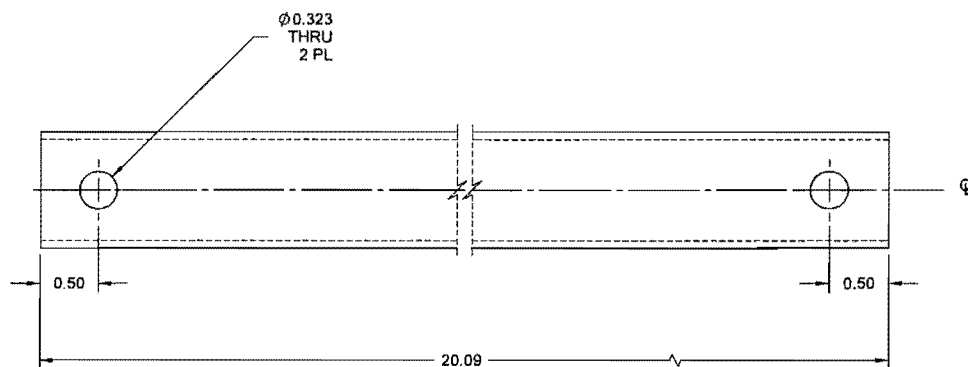
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D3769-5 TUBE

w/066892

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08.06.04

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